

Date: Thursday, 8/9/2007 11:19:34 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 33854		
Estimate Number	: 11736		
P.O. Number	:	Part Number	: D27951
This Issue	: 8/9/2007 S.O. No. :	Drawing Number	: D2795 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 33587	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 8/16/2007 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	: Est: B 04.05.14 Reformat; Added Step 5KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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Comment: Qty.: 1.3913 f(s)/Unit Total : 6.9563 f(s)
 6061-T6 Bar .50" x 6.0"
 Material: 6061-T6 (QQ-A-200/8) 0.500" thick
 (M6061T6B0.500x06.000)
 Identify for D2795-1
 Batch: *105145*

SG 07.08.10

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 6.000" x 0.05" x 15.800" long Bar

SG 07.08.10

5

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA106 and Dwg D2795
 Identify as D2795-1
 C'sink Ø0.375" x 100° as per Dwg D2795
 Deburr and Tumble

SG 07.08.10

5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG 07.08.10

5

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 33854

Part Number: D27951

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 07/08/10

(5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *st 240*

07/08/13 (5)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.08.13

Job Completion



C 207/08113

DART AEROSPACE LTD		Work Order:	
Description: Arm		Part Number:	D2795-1
Inspection Dwg: D2795 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	1.000	✓			
6.049	+/-0.010	6.049	✓			
R0.030	+/-0.010	.03	✓			
Ø0.191	+0.005/-0.000	.191	✓			
2.311	+/-0.010	2.310	✓			
0.250	+/-0.010	.250	✓			
9.358	+/-0.005	9.358	✓			
Ø0.507	+0.000/-0.001	.5066	✓			
2.033	+/-0.005	2.033	✓			
1.000	+/-0.010	1.000	✓			
2.500	+/-0.010	2.499	✓			
1.347	+/-0.010	1.347	✓			
0.250	+/-0.010	.250	✓			
R0.125	+/-0.010	.125	✓			
Ø0.375 x 100°	+0.005/-0.000	.375	✓			
0.500	+/-0.010	.498	✓			

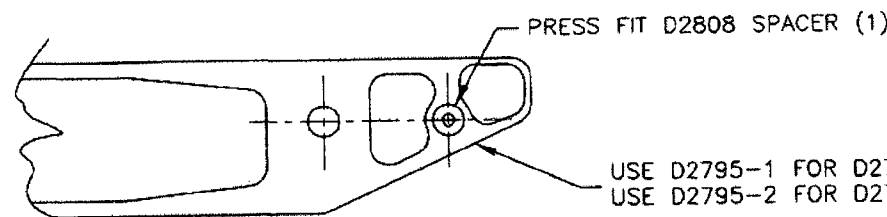
Measured by: <i>SG</i>	Audited by: <i>JML</i>	Prototype Approval:	N/A
Date: <i>07-08-10</i>	Date: <i>07/08/10</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

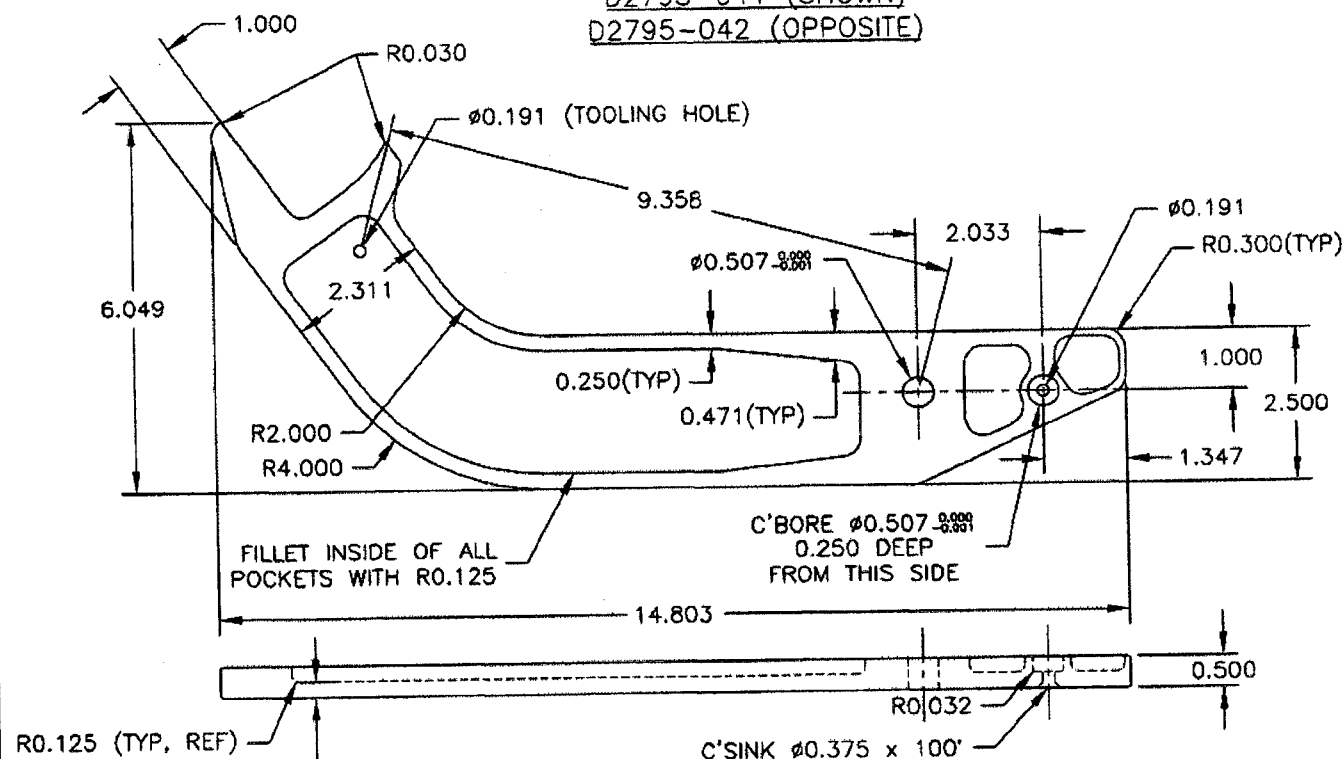


DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAMKESBURY, ONTARIO, CANADA
DATE 00.11.03	TITLE ARM	REV. A
A	00.11.03	SHEET 1 OF 1
	NEW ISSUE	SCALE 1:3

RELEASED
00.11.13



D2795-041 (SHOWN)
D2795-042 (OPPOSITE)



D2795-1 (SHOWN)
D2795-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2795-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED